

Work Order ID 65251

January 10, 2011 10:33:25 AM



Page 1

Item ID: D3573-8

Accept



Setup Start



Revision ID:

Stop



Item Name: Adapter

Start Date: 1/10/11 Start Qty: 6.00



Cust Item ID:

Required Date: 1/18/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3573	Rev A

100 0.00



BAND SAW

Bandsaw

Memo

0.00

Jcaspa Bandsaw

Cut blank 3.500" long

110 0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA679 and Dwg D3573

120 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65251

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Date:

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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

J. A 11/01/13

6

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

6 0 M 11/01/13

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

M112588

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:45
320
8:15

6 BL 11-01-14

Powder Coating

W/O:		WORK ORDER CHANGES					
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Work Order ID 65251

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Setup Start



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Item Name: Adapter

Start Date: 1/10/11 Start Qty: 6.00



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Required Date: 1/18/11 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 of 11 1/10/11

170

Identify as per dwg & Stock Location *Sylvia*

0.00



Packaging

Memo

0.00

Packaging

11/10/11

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/17

CMF

11-01-17

W/O:		WORK ORDER CHANGES					
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Picklist Print

January 10, 2011 10:33:24 AM

Page 1

Work Order ID: 65251



Parent Item: D3573-8



Parent Item Name: Adapter

Start Date: 1/10/11

Required Date: 1/18/11

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50 0		Purchased	No			100	f	8.4689	0.292	1.844211			



6061-T6 Bar .500 x 2.50

Location

Loc Qty

Loc Code

MAT02

8.46891

104366

8.46891

1.844

ml 11/01/11

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DART AEROSPACE LTD		Work Order: 65251
Description: Adapter		Part Number: D3573-8
Inspection Dwg: D3573	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.32	+/-0.030	3.317	—		Uven	ML-7
2.75	+/-0.030	2.750	✓			
0.36	+/-0.030	.358	—			
1.600	+/-0.010	1.598	—			
0.48	+/-0.030	.480	—			
2.38	+/-0.030	2.375	—			
1.420	+/-0.010	1.420	—			
1.813	+/-0.010	1.813	—			
Ø0.209	+0.005/-0.001	Ø.211	—			
Ø0.201	+0.005/-0.001	Ø.204	—			
Ø0.90 x 0.100	+/-0.010	Ø.899 X 100	—			
Ø0.500 x 0.310	+/-0.010	Ø.501 X 310	—			
0.390	+/-0.010	.398	—			
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø.388 X 100°	—			
R0.63	+/-0.030	R.63	—		Rad gage	REF
R0.13	+/-0.030	R.130	—			
R0.02	+/-0.030	R.020	—			

Measured by: <i>ML</i>	Audited by: <i>Y.A</i>	Prototype Approval: N/A
Date: 11/01/12	Date: 11/01/13	Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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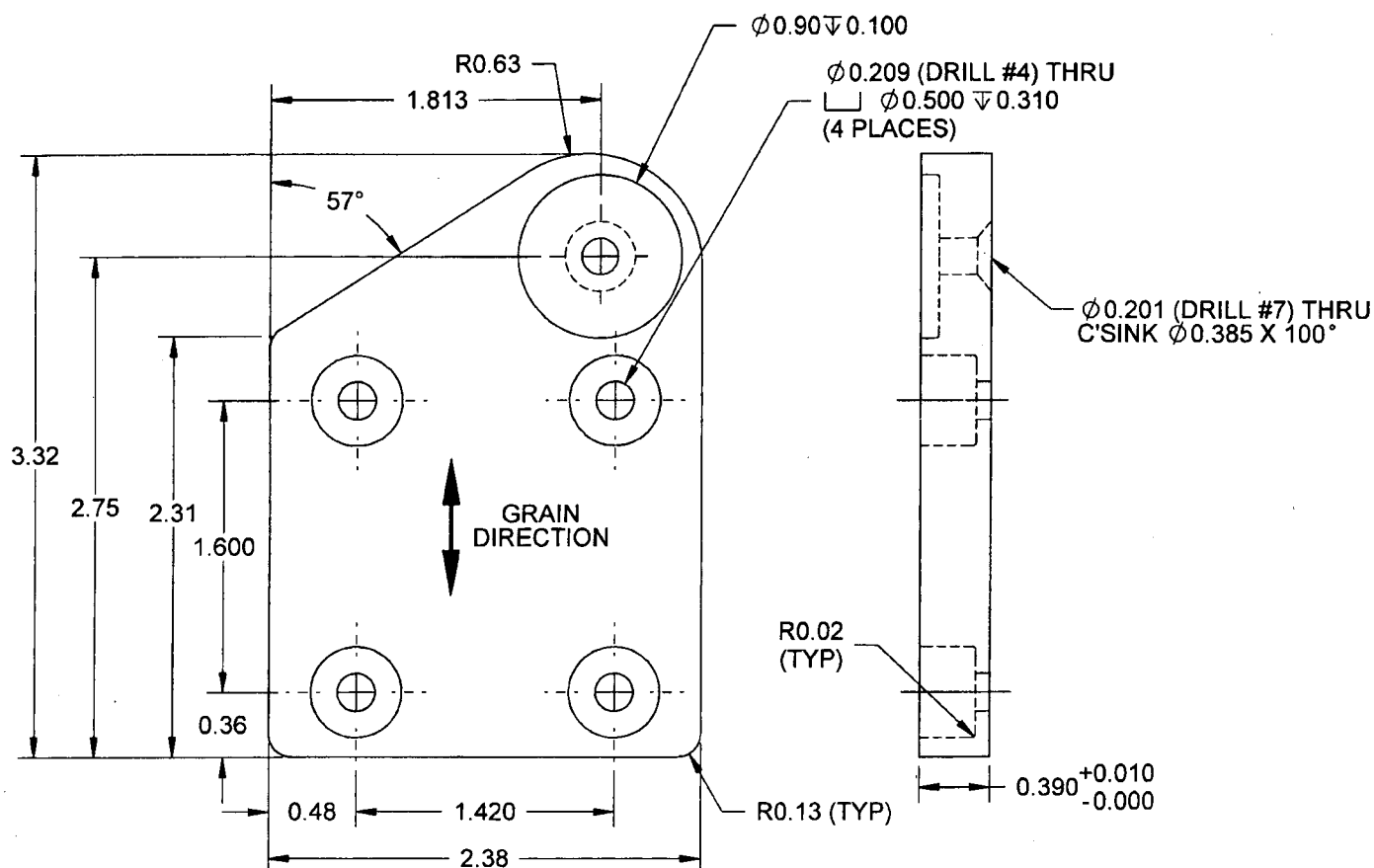
NOTE: Date & initial all entries

DART

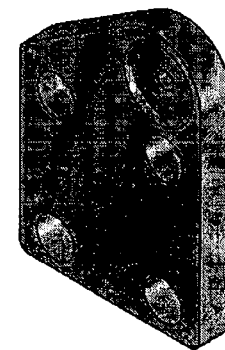
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3573	REV. A SHEET 4 OF 4
DATE 07.02.19	TITLE ADAPTER		SCALE 1:1

RELEASED
07.04.02 *[Signature]*

#65251



D3573-7 ADAPTER (SHOWN)
D3573-8 ADAPTER (OPPOSITE)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160
(REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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